



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-61
Job Sheet 194621-A



Part No: 20NR-61

Job Qty: 5 pcs

Part Name: Lock



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/14/19

Job Tracking No:

Due Date: 5/15/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG 20NR-61 Rev.7 IPP Rev. A 19.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	QC 2	5 pcs	5/15/19	5/15/19	0.00	0.00	QC 2 - 1	
120	QC 8	5 pcs	5/15/19	5/15/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	B.p 19-05-14
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
130	Outsource - 15 - Nickel Plate	5 pcs	5/15/19	5/15/19			GRO002-VC 7	2019-05-14
140	Packaging 2-1 - Receive - B4B	5 pcs	5/15/19	5/15/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	



Container No: S178698



Part: 20NR-61

Job No: 194621-A

Serial No/Batch: S178698

Revision: 7

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/19

MAY 22 2019

				Packaging 2 - 8 - B4B		
				Packaging 2 - 9 - B4B		
				Packaging 2 - 10 - B4B		
				Packaging 2 - 11 - B4B		
				Packaging 2 - 12 - B4B		
				Packaging 2 - 13 - B4B		
				Packaging 2 - 14 - B4B		
				Packaging 2 - 15 - B4B		
				Packaging 2 - 16 - B4B		
				Packaging 2 - 17 - B4B		
				Packaging 2 - 18 - B4B		
				Packaging 2 - 19 - B4B		
				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		
				Packaging 2 - 31 - B4B		
				Packaging 2 - 32 - B4B		
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
150	QC 6	5 pcs	5/15/19	0.00 0.00	QC 6 - 9	DAS
					QC 6 - 68	MAY 22 2019 68
					QC 6 - 61	9-89
					QC 6 - 40	
160	Packaging 3-1 - Stock - B4B	5 pcs	5/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	9-89 DAS 30 MAY 22 2019
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
170	QC 21 - SA	5 pcs	5/15/19	0.00 0.00	QC 21 - SA - 21	DAS 21 MAY 22 2019
					QC 21 - SA - 70	9-89

Part Op 130 - -Issue P/O; _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after
Descriptions: plating -Material type; 4140 -Certificate of Conformity is required
140 - Certificate of Conformity is required *CA 2106*

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 5/14/19 9:01 AM dart.lacelle.linda



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200
Fax 613 632-5246

20NR-61

Job Sheet 194621



Part No: 20NR-61

Job Qty: 8 pcs

Part Name: Lock



Part Weight: 0 lbs

Job Created: 5/6/19

Due Date: 5/15/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG 20NR-61 Rev.7 IPP Rev. A 19.02.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	NV5000 - 1	8 pcs	5/15/19	5/15/19	0.00	16.00	NV5000 - 1	
							NV5000 - 2	
105	NV5000 - 1 - B4B	8 pcs	5/15/19	5/15/19	0.00	8.00	NV5000 - 1 - B4B	PS 19-05-07
							NV5000 - 2 - B4B	
110	QC 2	8 pcs	5/15/19	5/15/19	0.00	0.00	QC 2 - 1	PS 19-05-07
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



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TEL.: 1 613 632-5200
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Container No: S178698



Part: 20NR-61

Job No: 194621

Serial No/Batch: S178698

Revision: 7

Inspector:

Exp Date:

Instructions:

Date: 05/07/19

Plex 5/6/19 1:50 PM Dart.lajeunesse.marie

120	QC 8	8 pcs	5/15/19	0.00	0.00	QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
130	Outsource - 15 - Nickel Plate	8 pcs	5/15/19			GRO002-VC	7
140	Packaging 2-1 - Receive - B4B	8 pcs	5/15/19	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	

					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	8 pcs	5/15/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
160 Packaging 3-1 - Stock - B4B	8 pcs	5/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
170 QC 21 - SA	8 pcs	5/15/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	

Part Op 100 - Issue serial number

Descriptions: 105 - 1-Machine as per folio FC660 FOLIO REV: AA DWG REV: 7 2-Deburr

130 - -Issue P/O; _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required

140 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.500X2.000 <i>FL</i>	4140 Steel Bar 1.500 X 2.000 <i>2.000 x 2.500</i>	4.3000 ft (.5375 ea)	100-NV5000 - 1	5058389 <i>4.333'</i>

Job Allocations

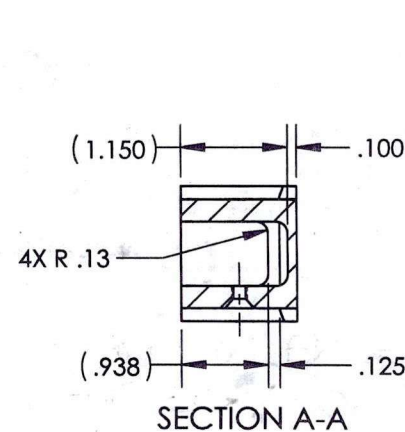
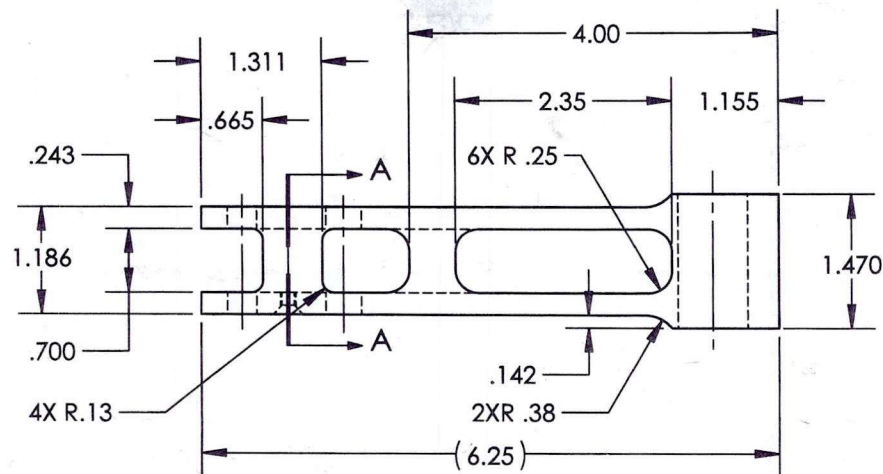
Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1 <i>FL</i>	MT-4140-B-1.500X2.000 <i>2.000 x 2.500</i>	4	6	0

Part Specifications

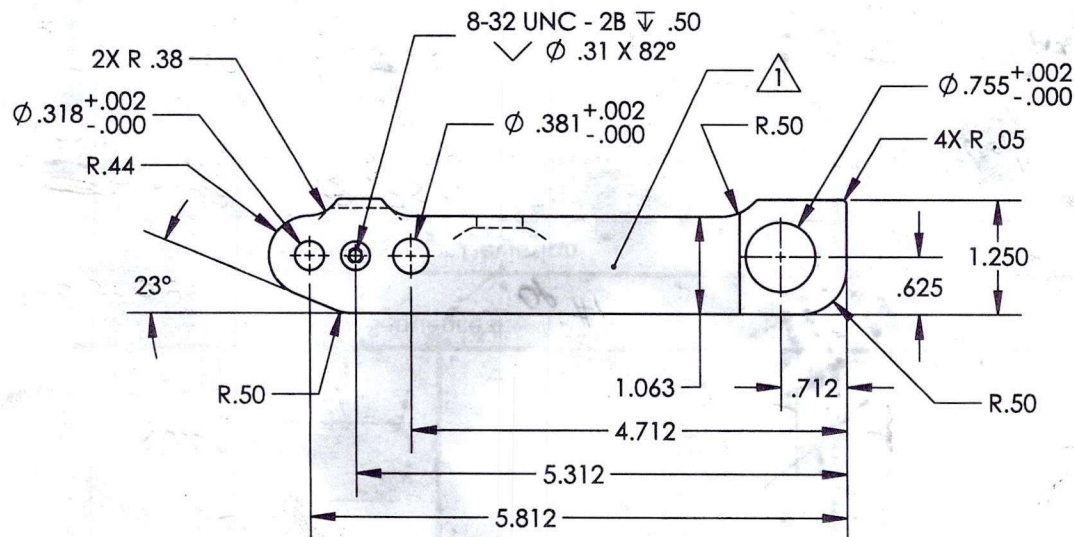
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM	7/18/2013	CFS	
6	14-0101	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE.	7/30/2014	DJN	RW
7	17-0081	ADDED DIM 4X R.13.	4/6/2017	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194624
ML5
1905-06



NOTES:

1. MACHINE ENGRAVE BATCH NUMBER.
2. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
3. BREAK ALL SHARP EDGES AND CORNERS .020.

USED ON
20NR
8NR

DART AEROSPACE	
LOCK	
TITLE	
DWG NO.	20NR-61
REV	7
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
TREAT RC 30-32	DIMENSIONS ARE IN INCHES
FINISH SEE NOTE 2	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CANAM	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: SM 04/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 04/10/2017	USED ON MODEL
QA APPR: JL 04/10/2017	
APPROVED: JAG 04/13/2017	
SCALE 1:2	DATE 5/20/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-61	1	LOCK	4140/4142	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043454



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043454

PO Date: 5/14/19

Due Date: 5/17/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: ****RUSH****

E-MAILED
2019-05-15

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193661	20NR-14	Load Rail (Outside Processing - Nickel Plate)-Issue P/O P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	5/17/19	9 pcs	0 pcs	9 pcs	\$5.60/pcs	\$50.40
2	194621-A	20NR-61	Lock -Issue P/O; -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Material type; 4140 -Certificate of Conformity is required	Firmed	-	5/17/19	5 pcs	0 pcs	5 pcs	\$5.60/pcs	\$28.00
3	192380	20NR-85	Lifting Bolt -Issue P/O; -Nickel plate, QQ-N-290A, Class 2, Grade E or F -Material type; 4340 -Certificate of Conformity is required	Firmed	-	5/17/19	7 pcs	0 pcs	7 pcs	\$8.91/pcs	\$62.37



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PURCHASE ORDER

POHB043454



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194245	C3-C-8	Lifting Bushing -Issue P/O; -Nickel plate, MIL-C-26074 Class 2 Grade B OR QQ-N-290A, Class 2, Grade E -Material type; 4140 -Certificate of Conformity is required	Firmed	-	5/17/19	20 pcs	0 pcs	20 pcs	\$0.85/pcs	\$17.00

20 x MAY 22 2019

Grand Total: \$157.77

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/15/19 9:15 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(019207-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.grouppaltech.com

Bon de Livraison / Packing Slip**019207-1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
16-May-2019		SVETLANA DORZHIYEVA		POHB043454				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	20NR-14 Rev.	20NR-14 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL-PLATE, QQ-N-290,CLASS2, GRADE E OR F NICKEL PLATE 0.0004-0.0006 BAKE AFTER PLATING	E-NICKEL STEEL CH	9	9	0	0	0
2	20NR-61 Rev.	20NR-61 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE QQ-N-290 CLASS 2 GRADE E OR F 0.0004 TO 0.0006 THICK BAKE AFTER PLATING MATERIAL TYPE; 4140	E-NICKEL STEEL CH	5	5	0	0	0
3	20NR-85 Rev.	20NR-85 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE QQ-N-290 CLASS 2 GRADE E OR F MATERIAL TYPE; 4140	E-NICKEL STEEL CH	7	7	0	0	0
4	C3-C-8 Rev.	C3-C-8 01 -E-NIC STEEL 200 [E-NICKEL STEEL 200] NICKEL PLATE, MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A, CLASS 2, GRADE E MATERIAL TYPE; 4140	E-NICKEL STEEL CH	20	20	0	0	0

RECEIVED

MAY 21 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

4 boxes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.